

[illegible]

Page 1

**Accept**



**Setup Start**

**Stop**

**Abstract**

**Customer:**



Run Start



Date: 01/12/29

### Tooling:

**Date:**

**QC:**

**Date:****SPC (Y/N):**

**Date:**

**Stop**

**Insp.  
Stamp**

Rev H

0.00



## Large Fab

0.00

## Large Fab

## Large Fab

## Memo

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
3- tack weld mesh on basket as per dwg D2221  
A/R ER316 S.S. Rod Batch: 111585 *Ed 10-17-01*

\*\*\*PLEASE NOTE\*\*\*

IF MAKING -041A OR -043A :  
DRILL HOLES FOR GAS SPRING  
IN D3825-041 AS PER  
DSI 9473

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

## Quality Control

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64188**

Monday, November 29, 2010 3:36:32 PM

Page 2

Item ID: D2221

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 Basket Base

Start Date: 11/29/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/7/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

Handwritten notes and stamps:

- Handwritten "F1" and "MA" in the Plan Code column.
- Handwritten "10" in the Accept Qty column.
- Handwritten "12" in the Reject Qty column.
- Handwritten "09" in the Reject Number column.
- Handwritten "1" in the Insp. Stamp column.
- Handwritten "10-12-9" in the Insp. Stamp column.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector








Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Monday, November 29, 2010 3:36:32 PM

Item ID:	D2221	Accept		Setup	Start	
Revision ID:						
Item Name:	350 Basket Base				Stop	
Start Date:	11/29/2010	Start Qty: 1.00		Cust Item ID:		
Required Date:	12/7/2010	Req'd Qty: 1.00		Customer:		
Reference:						
Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start 
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop 

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 64188**

Monday, November 29, 2010 3:36:32 PM

Page 4

Item ID: D2221

Accept

Revision ID:

Item Name: 350 Basket Base

Start Date: 11/29/2010 Start Qty: 1.00

Required Date: 12/7/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*ES 10/12/09 @**10/12/10**U 10-12-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

Monday, November 29, 2010 3:36:38 PM

Page 1

Work Order ID: 64188

Parent Item: D2221

Parent Item Name: 300 Basket Base



Start Date: 11/29/2010

Required Date: 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2221-1  Rib		Manufactured	No			100	Each	16.0000	1				
----------------------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

Location	Loc Qty	Loc Code
WA	16	
61424	1	
62519	3	
63628	12	

✓ D2221-5  Rib		Manufactured	No			100	Each	6.0000	2	2			
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	6	
62996	6	

✓ D2221-7  Rib		Manufactured	No			100	Each	3.0000	1	1			
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	3	
62997	3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 29, 2010 3:36:38 PM

Work Order ID: 64188

Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 11/29/2010

Required Date: 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3	Manufactured	No	100	Each	6.0000	2	2
							<i>Cpl 10.12.01</i>
Basket Hinge							
				</			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 29, 2010 3:36:38 PM

Page 3

Work Order ID: 64188

Parent Item: D2221

Parent Item Name: 35 Basket Base

Star. Date: 11/29/2010

Required Date: 12/7/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041	Manufactured	No	100	Each	6.0000	2	2
Rib Assembly (Basket End)							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		6				
	63425		6				
✓ D3826-041	Manufactured	No	100	Each	6.0000	2	2
Rib / Gusset Assembly							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		6				
	63119		6				
✓ D3827-041	Manufactured	No	100	Each	3.0000	1	1
Rib Assembly (Inboard)							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		3				
	62993		3				
✓ D3832-1	Manufactured	No	100	Each	2.0000	1	1
Mesh (Base)							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		2				
	63227		2				
✓ D3833-1	Manufactured	No	100	Each	10.0000	2	2
Mesh (Base End Face)							
	<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>		
	WA		10				
	63255		10				

Monday, November 29, 2010 3:36:38 PM

Shop Packet Print

Page 3

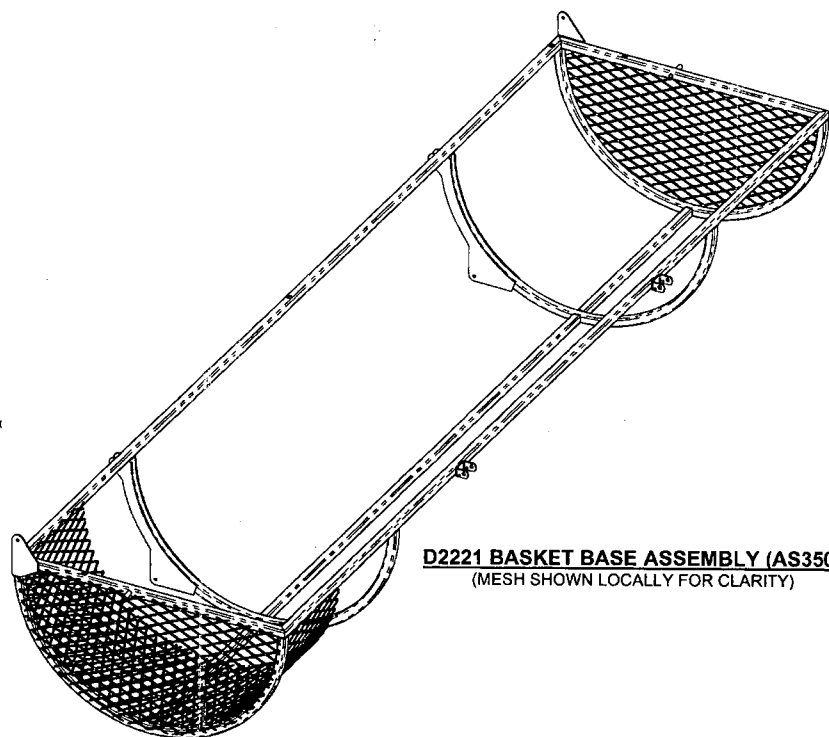
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

**RELEASED**  
08/11/18

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 64188

*BA 10-11-29*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.82 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	BW	DRAWING NO.	REV. H
MFG. APPR.	BW	D2221	SHEET 1 OF 5
APPROVED	BW	TITLE	SCALE
DE APPR.	BW	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

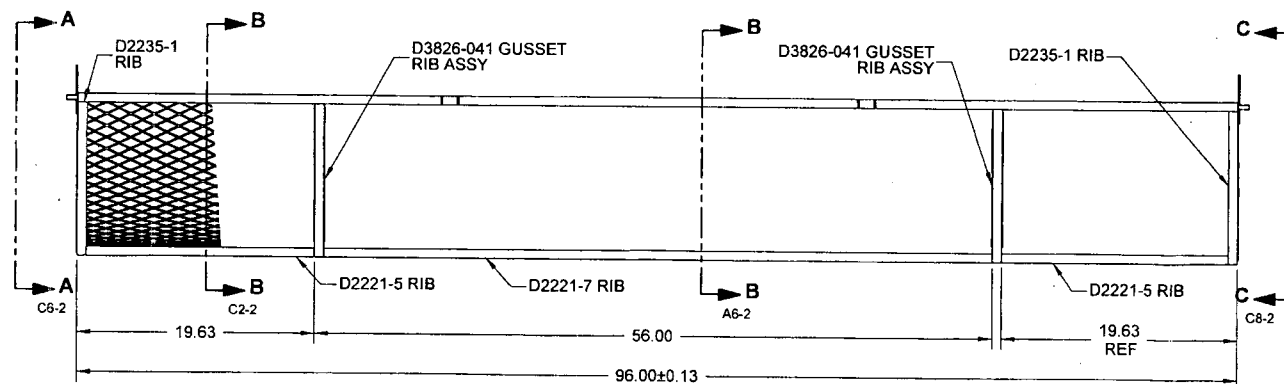
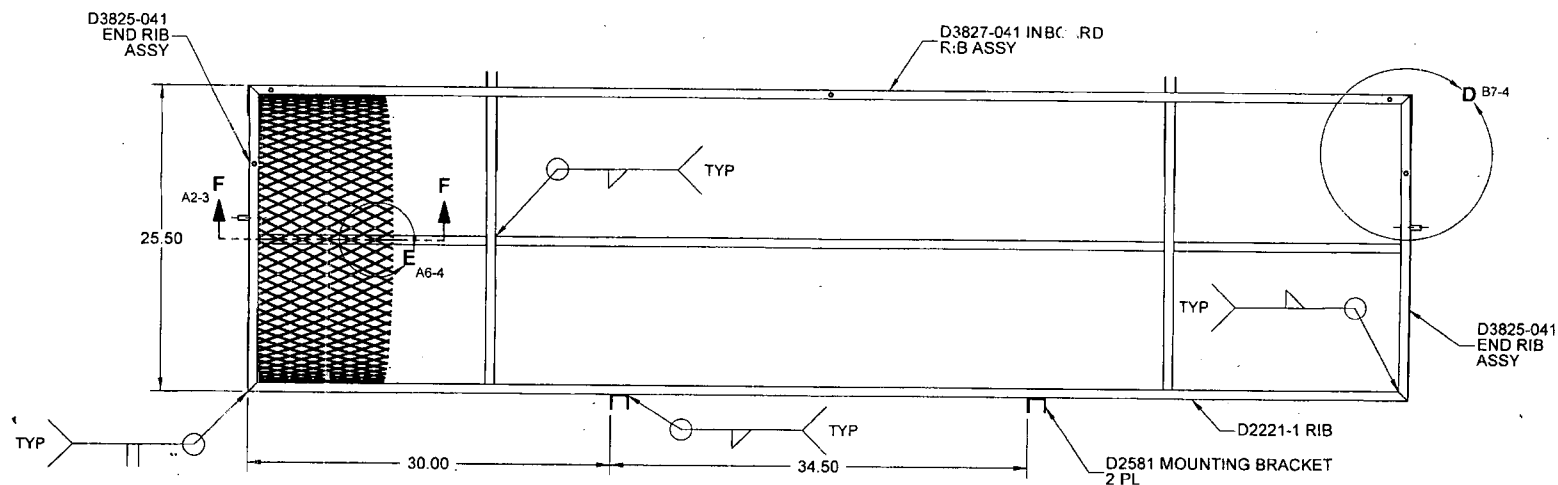
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




**NOTE:** Date & initial all entries





**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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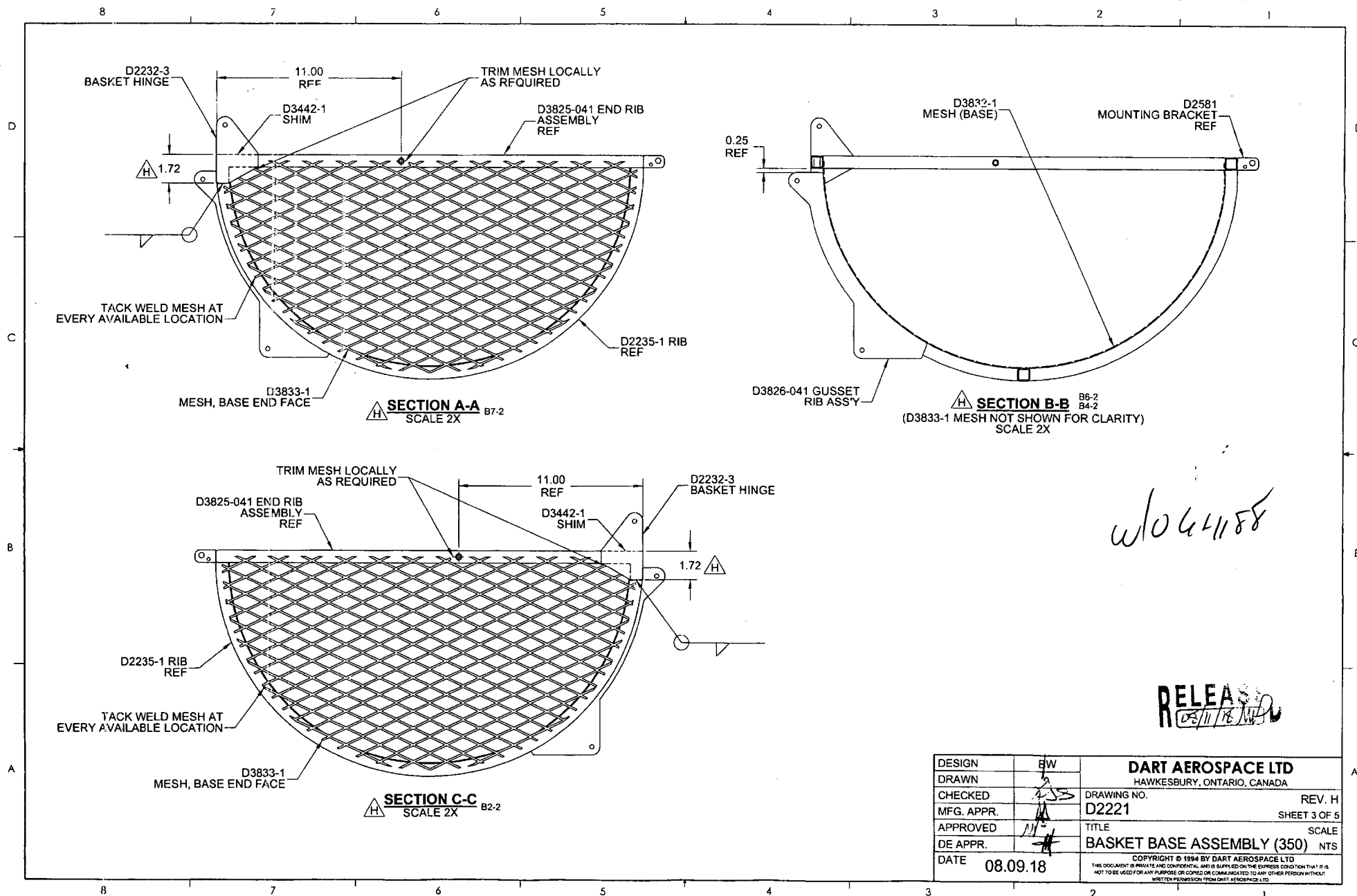
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



W1064158

RELEASED  
02/11/16

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SS	DRAWING NO.	REV. H
MFG. APPR.	1/1	D2221	SHEET 3 OF 5
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

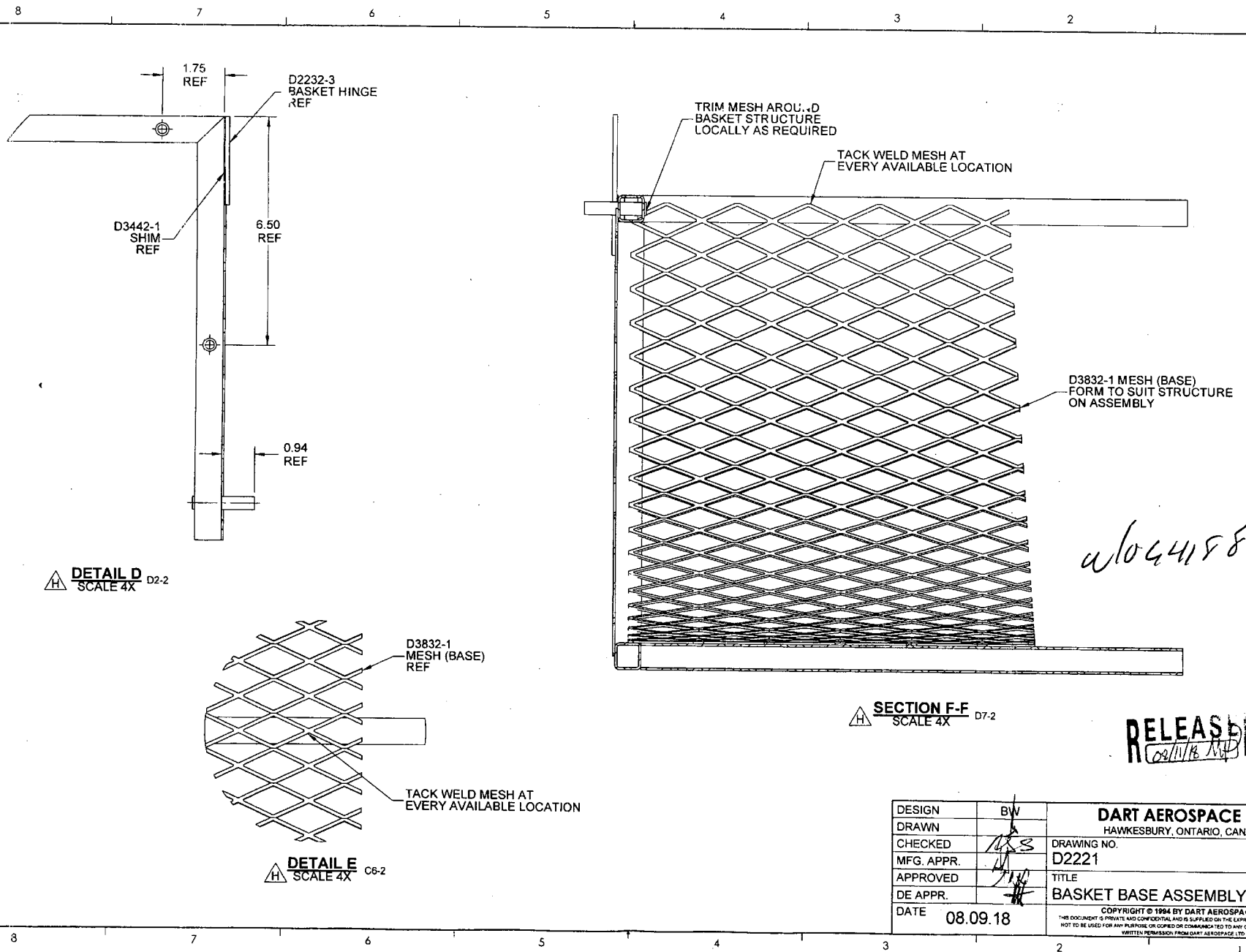
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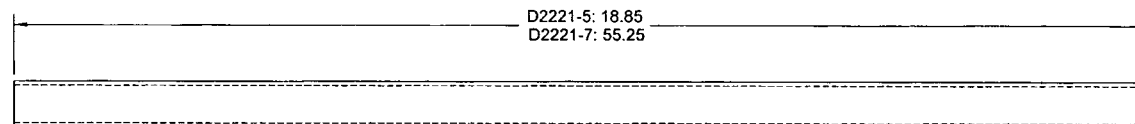
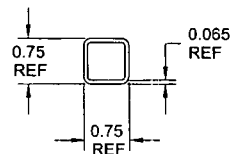
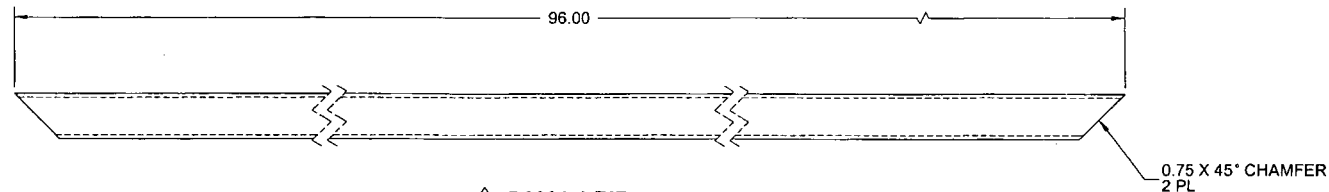
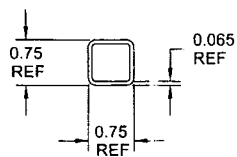
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*W/O 64158*

**RELEASED**  
*08/10/18*

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>AD</i>	D2221	SHEET 5 OF 5
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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